

# Work Order ID 59445

Friday, June 04, 2010 11:24:17 AM



Page 1

Item ID: D5951

Accept



Setup Start



Revision ID:

Item Name: Saddle, 205

Stop



Start Date: 6/4/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 6/10/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

*Handwritten initials*

Date:

*10-6-04*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D5951

Rev B

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine as per folio D5951, Ensure Batch Number is entered  
Keyway ☒ 3-Deburr & Tumble

*Handwritten initials*

*10/06/21*

*Handwritten signature*

*Handwritten '6' and '0'*

110

0.00



QC1- Inspect dimensions to dimension sheet

QC

Memo

0.00

Quality Control

*Handwritten initials*

*10/06/21*

*Handwritten signature*

*Handwritten '6' and '0'*

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

*Handwritten signature*

*10/06/23*

*Handwritten '6' and '0'*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

(b) (7)(C), (b) (7)(D)

Page 2

**Accept**

**Setup Start**

**Stop**

**Cust Item ID:**

100

**Customer:**

**Reference:**

Run Start

[illegible]

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

**Stop**

[illegible]

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

**Insp.  
Stamp**

0.00



**HandFinish**

## Hand Finishing

## Memo

0.00

⑥ BL 10-6-23

0.00

**Abstract**

**Powdercoat**

## Powder Coating

11/14/84

## Memo

0.00

START TIME:

2:10

**□OVEN TEMPERATURE:**

320 ☐ FINISH TIME:

2. ✓/0

6 BL 10-6-23.

0.00



QC

## Quality Control

## Memo

0.00

P. 110/5/27 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 59445

Friday, June 04, 2010 11:24:17 AM



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Item ID: D5951

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, 205

Start Date: 6/4/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 6/10/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

Identify as per dwg & Stock Location: 430

0.00



Packaging

Memo

0.00

Packaging

P.C. 10/6/24 (6)

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/24 AF

10/06-24  
(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Friday, June 04, 2010 11:24:22 AM

Page 1

Work Order ID: 59445



Parent Item: D5951



Parent Item Name: Saddle, 205



Start Date: 6/4/2010

Required Date: 6/10/2010

Comments: IPP Rev:E Re-Format 05-11-29 JLM  
IPP Rev:E Re-Format 05-11-29 JLM

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status												
D6101-013		Manufactured	No			100	Each	20.0000	1	6															
																									
Saddle Billet																									
																									

Location

Loc Qty

Loc Code

MAT47

20

46413

20

6 DTA 10/06/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 59445
<b>Description:</b> Outer Fwd Saddle		<b>Part Number:</b> D5951
<b>Inspection Dwg:</b> D5951	<b>Rev:</b> B	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.437	0.444		0.440	0.440	0.440	0.440		
B	1.745	1.755		1.753	1.750	1.750	1.750		
C	5.245	5.255		5.252	5.250	5.250	5.250		
D	6.995	7.005		7.003	7.000	7.000	7.000		
E	5.240	5.260		5.250	5.250	5.250	5.250		
F	4.745	4.755		4.747	4.750	4.750	4.750		
G	0.315	0.322		0.317	0.321	0.321	0.321		
H	1.522	1.532		1.524	1.527	1.527	1.527		
I	3.048	3.058		3.053	3.053	3.053	3.053		
J	4.575	4.585		4.580	4.580	4.580	4.580		
K	0.315	0.322		0.317	0.322	0.322	0.322		
L	0.495	0.505		0.500	0.500	0.500	0.500		
M	0.490	0.510		0.503	0.503	0.503	0.503		
N	1.615	1.635		1.631	1.632	1.632	1.632		
O	7.990	8.010		8.002	8.002	8.002	8.002		
P	2.240	2.260		2.253	2.245	2.245	2.245		
Q	0.307	0.312		0.309	0.310	0.310	0.310		
R	0.760	0.765		0.760	0.764	0.764	0.764		
S	0.490	0.510		0.507	0.501	0.505	0.503		
T	1.375	1.395		1.391	1.3815	1.382	1.390		
U	2.000	2.020		2.013	2.015	2.004	2.009		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <i>AMW</i>
Date: <i>10/06/22</i>

Audited by: <i>[Signature]</i>
Date: <i>10/06/23</i>

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	
C	06.12.06	Dimensions A,G,K,L,N,P revised	KJ/EC	
D	07.06.15	Dimension G revised	KJ/JLM	
E	08.04.21	Dimension E revised	KJ/DD	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 59445
<b>Description:</b> Outer Fwd Saddle		<b>Part Number:</b> D5951
<b>Inspection Dwg:</b> D5951	<b>Rev:</b> B	<b>Page</b> 1 of 1

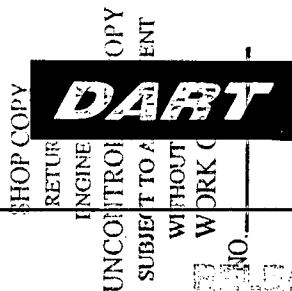
Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	5	6	<del>7</del>	<del>8</del>		
A	0.437	0.444		0.440	0.440				
B	1.745	1.755		1.750	1.750				
C	5.245	5.255		5.250	5.250				
D	6.995	7.005		7.000	7.000				
E	5.240	5.260		5.250	5.250				
F	4.745	4.755		4.750	4.750				
G	0.315	0.322		0.321	0.321				
H	1.522	1.532		1.527	1.527				
I	3.048	3.058		3.053	3.053				
J	4.575	4.585		4.580	4.580				
K	0.315	0.322		0.322	0.322				
L	0.495	0.505		0.500	0.500				
M	0.490	0.510		0.503	0.505				
N	1.615	1.635		1.632	1.632				
O	7.990	8.010		8.000	8.000				
P	2.240	2.260		2.245	2.245				
Q	0.307	0.312		0.310	0.310				
R	0.760	0.765		0.763	0.763				
S	0.490	0.510		0.499	0.507				
T	1.375	1.395		1.390	1.385				
U	2.000	2.020		2.010	2.005				
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

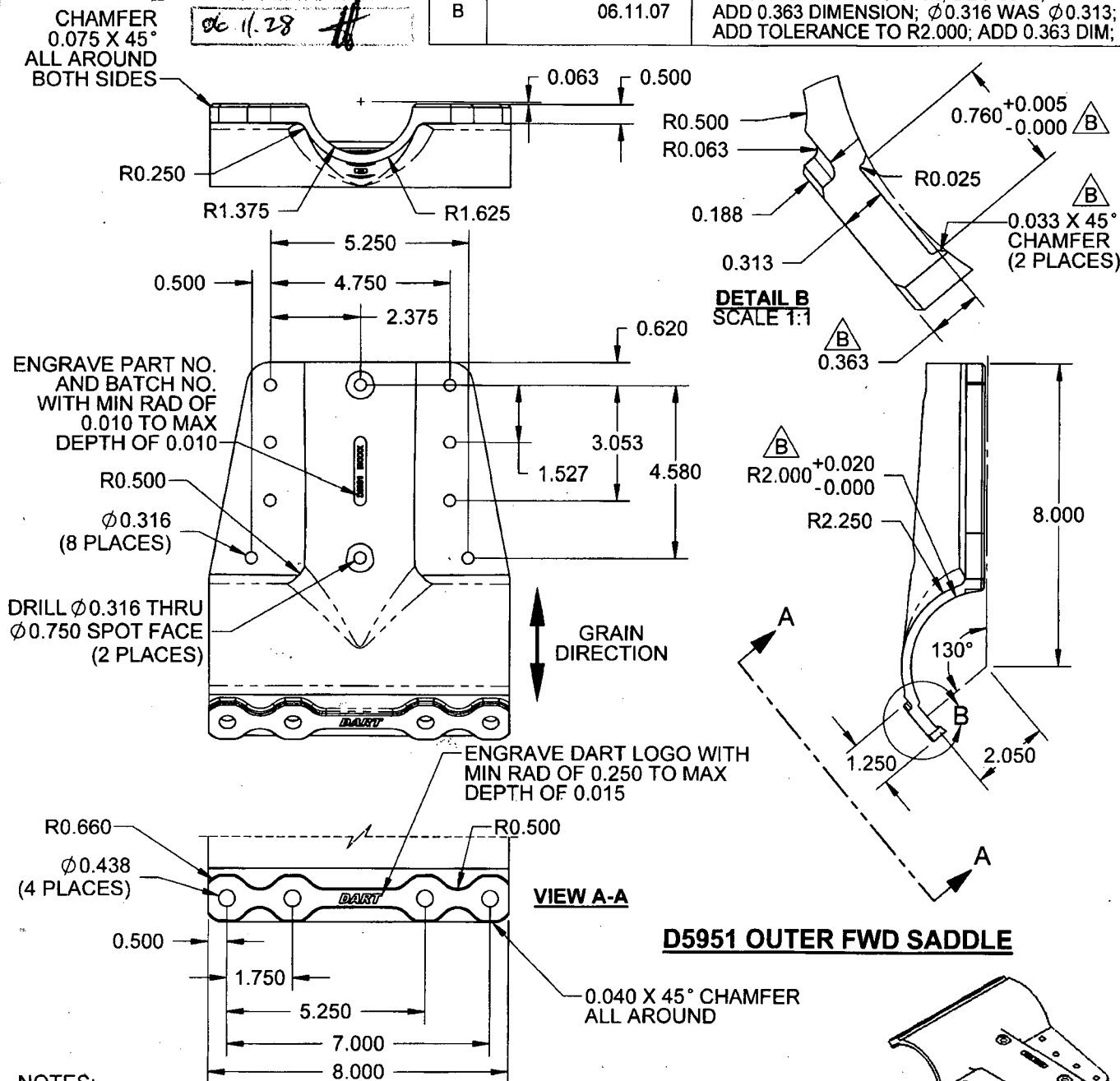
Measured by:	DTD
Date:	10/06/22

Audited by:	RF
Date:	10/20/23

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
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D	07.06.15	Dimension G revised	KJ/JLM	
E	08.04.21	Dimension E revised	KJ/DD	



DESIGN <b>BW</b>	DRAWN BY <b>CB</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
CHECKED <b>CE</b>	APPROVED <b>[Signature]</b>	DRAWING NO. <b>D5951</b>
DATE <b>06.11.07</b>	TITLE <b>OUTER FWD SADDLE</b>	REV. B SHEET 1 OF 1
REV <b>A</b>	DATE <b>97.05.06</b>	DESCRIPTION <b>NEW ISSUE</b>
REV <b>B</b>	DATE <b>06.11.07</b>	DESCRIPTION INCORPORATE DEO 9102, DEO 9079; ADD 0.363 DIMENSION; $\phi 0.316$ WAS $\phi 0.313$ ; ADD TOLERANCE TO R2.000; ADD 0.363 DIM;



**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 PER QQ-A-250/12  
(MAKE FROM D6101-013 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

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